

Date: Tuesday, 3/20/2007 1:52:17 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FWD X-TUBE EXTENDED HEIGHT GEAR (-011)
Job Number	: 31373		
Estimate Number	: 10007		
P.O. Number	: N/A	Part Number	: D205596101
This Issue	: 3/20/2007 S.O. No. : N/A	Drawing Number	: D205-596-101 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : LANDING GEAR	Drawing Revision	: A
Previous Run	: 31372	Material	: N/A
Written By	: <u>[Signature]</u>	Due Date	: 4/15/2007 Qty: 1 Um: Each
Checked & Approved By	: <u>[Signature]</u>		
Comment	: Est Rev 0 Removed Bending 05-10-25 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy D205-594 bluefile & type labels per PPP D205-596-101 CHG001

[Signature] KJ 07.04.03 (1)

2.0	D2889	FWD Crosstube
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

FWD Crosstube

Pick:

Qty	Part number	Description	Batch
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1	D2889	Fwd Crosstube	294B2
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3.0	BENDING	BENDING MACHINE
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Comment: BENDING MACHINE

Bend as per Dwg D2889

N/A [Signature]

4.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

Mark 31.53" for cutting from tangential line in the straight section from D2889 as per Dwg wall template.

07070412

5.0	QC15	DIMENSIONAL CHECK OF X-TUBES
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Comment: DIMENSIONAL CHECK OF X-TUBES

[Signature] 070412

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 3/20/2007 1:52:17 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD-X-TUBE EXTENDED HEIGHT GEAR (-011)

Job Number: 31373

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Cut as per Dwg D205-596-101

2-Deburr & Inspect for surface damage. Polish cut surface. Scribe part # and end of tube.

Batch # on one 31373

5b 7-5-3

7.0

QC15

DIMENSIONAL CHECK OF X-TUBES



Comment: DIMENSIONAL CHECK OF X-TUBES

205-030

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat per QSI 005 4.1

5b 7-5-3

9.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

Prime inside and outside with Immron per QSI 005 4.2

m 070524(1)

FC

07 05 24 (1)

10.0

QC14

Inspect Spray Paint



Comment: Inspect Spray Paint

205-280

11.0

D2856600851

Abrasion Strip



Comment: Qty.: ~~2.000~~ Each(s)/Unit Total : 2.0000 Each(s)
Abrasion Strip 7091

Pick:

Qty Part number Description Batch
2 D2856-600-851 Abrasion Strip

26650

RT 07-05-28

12.0

D28931

Support



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Support

Pick:

Qty Part number Description Batch
2 D2893-1 Support

29524

RT 07-05-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/05/29
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 3/20/2007 1:52:17 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD X-TUBE EXTENDED HEIGHT GEAR (-011)

Job Number: 31373

Part Number: D205596101

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

MS2192024

Clamp(per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number

Description Batch

4 MS21920-24

Clamp

M101810

RT 07-05-28

14.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install Abrasion strips per QSI 035 position using DT8582. Install supports and clamps per Dwg
D205-596-101. Torque clamps to 80-100 in lb. Seal edges of support using Sikaflex

RT 07-05-28

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-596-101

Location:

REV: E

07/05/29

17.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/05/29

Job Completion



07/05/29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

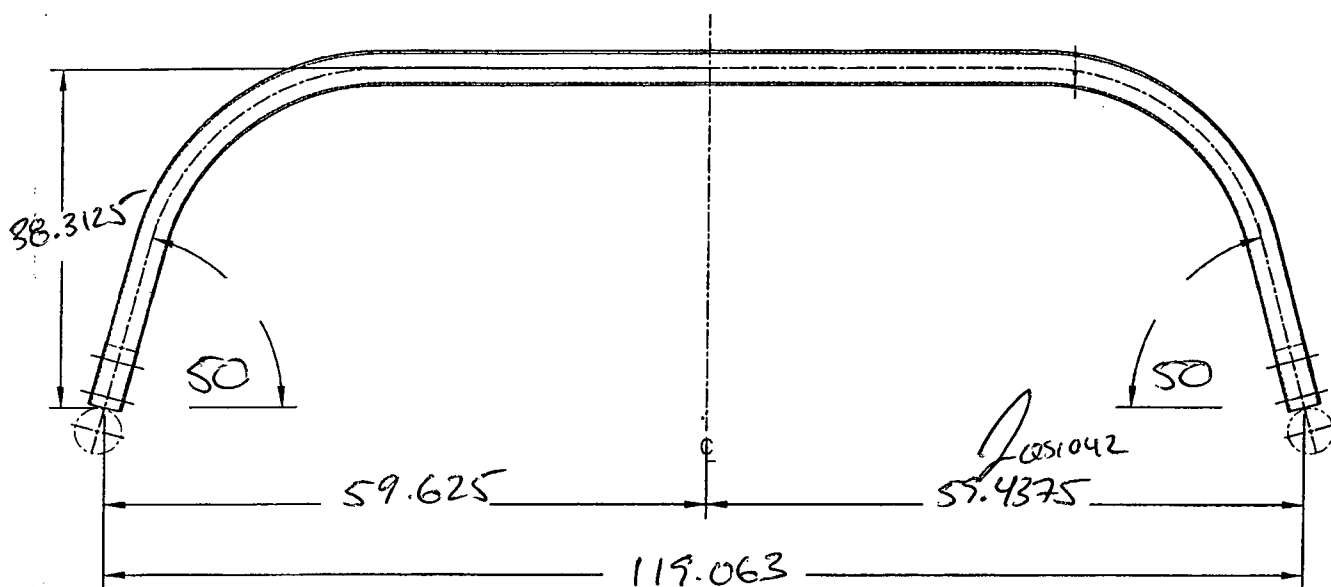
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	31373
Description: Crosstube High-High Fwd		Part Number:	D205-596-101
Inspection Dwg: D205-596-101 Rev: A		Page 1 of 1	

Required Dimension	Min	Max
Height	38.2	38.4
1/2 Span	59.5	59.7
Angle	49	52
Total Span	119.0	119.4

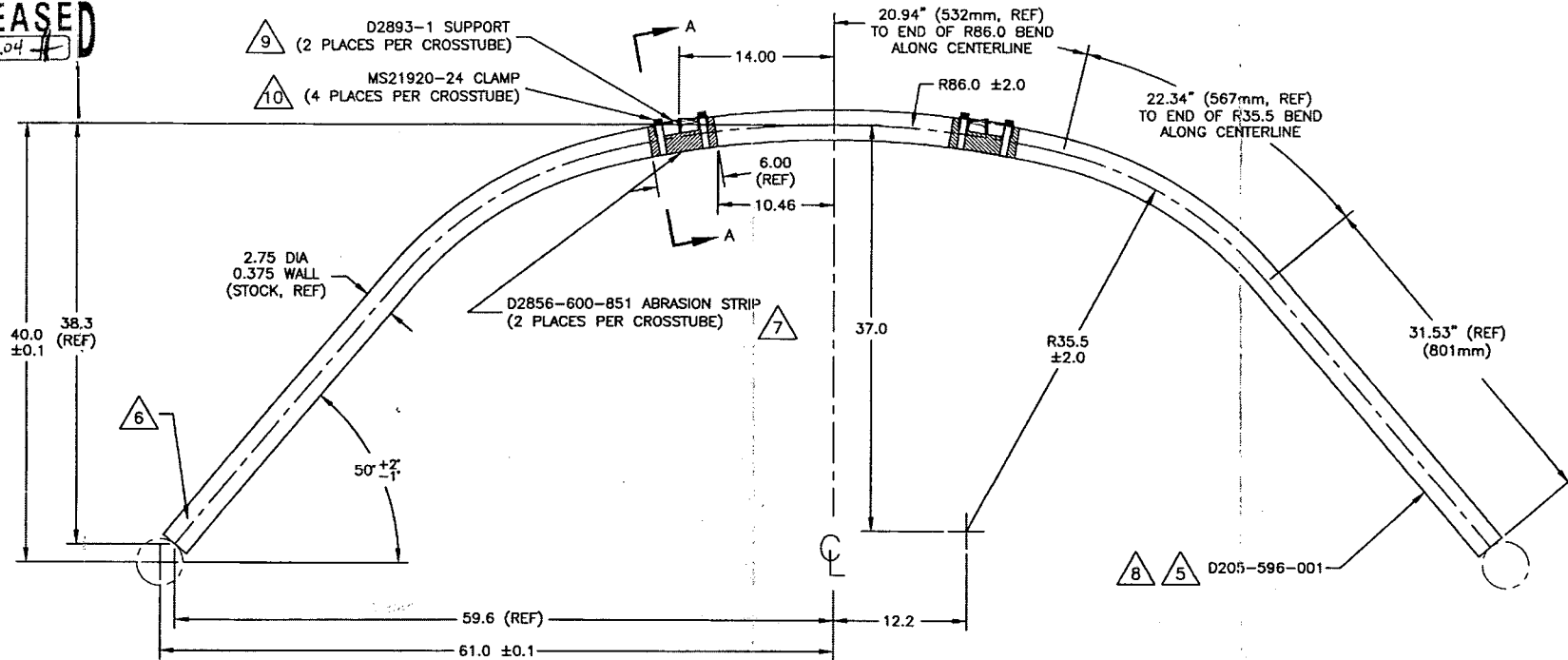


Comments

QC15 Inspection	J 070412
Date	

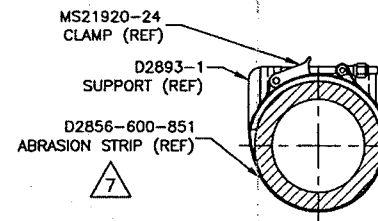
Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	J

RELEASED
02.06.04



GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) MATERIAL: MANUFACTURE FROM D6005-180
FINISHED LENGTH = 149.60
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) BEND PROGRESSIVELY WITH A MINIMUM OF 3 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 6) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS
- 7) INSTALL D2856-600-851 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D2893-1 SUPPORT, PER QSI 035
- 8) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005\" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 9) SEAL EDGES OF SUPPORTS USING SIKAFLEX-241/-291 SEALANT (OPTIONAL)
- 10) TORQUE CLAMPS 80 TO 100 IN-LB



SECTION A-A
SCALE 2:5

A		02.05.27	NEW ISSUE
DESIGN	✓	DRAWN BY	CP
CHECKED	✓	APPROVED	✓
DATE	02.05.27	TITLE	XTUBE ASS'Y (HI-HI FWD)
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		D205-596-101	

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